Work Orde		7785		*10	7785*						Page	1
Item ID: Revision ID:	D4020-3			Accept	*N900	040	100)* s	etup Star	I A	S1*	
Item Name:	Mesh (350 Bas	sket Short, Base)							Stop	, *N	S2*	
Start Date:	10/02/13	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date:	10/16/13	Req'd Qty: 1.00	*1*		Customer:							
Reference:		·			· · · · · · · · · · · · · · · · · · ·		_	D	tun Star	t		
Approvals:	Process Plan	n: ML5	Date: /3-/0-08	Z_Tooling:	Da	ite:	····	Л		1/1	R1*	
	QC:		Date:	SPC (Y/N):	Da	ıte:			Stop	' *N	R2*	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revi	sion Nbr							A 1000 A			
D4020 •	Α Α											
400		FLOW WATER JET		0.00					1.1			
Shear		Memo		0.00					SY 1	3-10	02	-
Shear		1-Cut mesh necessary)	ar 56.00" (when mesh is or	n D4017-041 trim mes	sh to finish size if							
120	,	QC6- Inspect dimension	s to drawing	0.00) >C 13·10·0	. ~		1				
120 QC Quality Control		Memo		0.00	SC 13.70.C	/g.		1x	·			
130		Identify as per dwg & St	ock Location: WAL	0.00					_	,		£.
130			·						- L	112.	10.00	ِ ر
Packaging		Memo		0.00						, — , 		<

Packaging

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE		_			
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WOIK OIG	٠١٠,					Rework	1		Skid-tube	Crosstube	٦		Water Jet		Engineering
Part I	۷o.					Scrap	1 1	i i	Machining	Small Fab	7	Proc	l. Eng. Coor.		Quality
	•					Use-as-is] [Thern	noforming	Finishing]	Rec/Stor	e/Packaging		Other
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Soot			ſ		Doscri	ption of work order update		nitial	Δ.σ.	tion	T	Sign &			
Root		Data	Chan	O4	1		i					Date	Verificatio	_	QC Inspector
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		Bending				Bend		Grain			_	valized		L	Pressure/Forced
		Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardwa	ire		_	ver/Under		<u> </u>	Temperature/Cure
		Cracks			1	Broken/Damaged	1	Inspect	ion Incomplete		Pa	art Incorrec	t		Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Work Order ID 107785 *107785* Page 2 October-02-13 7:46:29 AM Accept D4020-3 *N900040100* Item ID: Setup Start **Revision ID:** Stop Mesh (350 Basket Short, Base) Item Name: Start Qty: 1.00 **Start Date:** 10/02/13 **Cust Item ID:** Required Date: 10/16/13 **Req'd Qty:** 1.00 **Customer:** Reference: Run Date: _____ Tooling: Approvals: Process Plan: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject. Reject Insp. Work Center ID Description Qty Qty Number Code **Run Hours** Stamp QC21- Final Inspection - Work Order Release 0.00 140 *140* QC 0.00 Memo

Quality Control

1/18/10/

										DQA:	Date:	
NCR:	res / N	0			WORK ORDER NON-O	CON	IFORM	MANCE / UPDATE		04 61	Data	
			-							QA Closed:	Date:	
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Part N	No				Rework Scrap Use-as-is Work Order Update		1 Thern	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	lr	nitial	Action		Sign &		·
Cause	Dat	e Step	Qty		or Non-conformance	Chi	ef Eng	Description		Date	Verification	QC Inspector
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	Bendi	ng			Bend		Grain			Ovalized		Pressure/Forced
	Centr	e Not Conce	entric to	O/S	_BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crack	5			Broken/Damaged		Inspecti	on Incomplete	\vdash	Part Incorred		Weld
	Crush	ed/Crimped	i		Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat	reat			Countersink		Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio October-02-13 7:46:33 AM

Work Order ID: 107785

107785

Parent Item:

D4020-3

D4020-3

Parent Item Name: Mesh (350 Basket Short, Base)

Start Date: 10/02/13

Required Date: 10/16/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: new issue DD 09.11.26 verified by:EC

per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	1,438.273	19.1516	21			,

M304FX0 75-16F

Expanded Metal Flat SS

Location	Loc Qty	Loc Code	S
WA007	1438.273598		
125457	0.00004402		
M126052	42.02608		Address of the second
M126134	108.417474		
M126500	73.83		
M126899	574		
M127024	640		

M/26899 - 21 SS 13.10.02

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											-				·
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	-				-	Rework	1		Skid-tube	Crosstube]		Water Jet		Engineering
Part N	No.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	•					Use-as-is		Therm	noforming	Finishing	Red	c/Sto	re/Packaging		Other
NCR I	۷o.					Work Order Update]		Large Fab	Composite]		Supplier		
Root					Descri	tion of work order update		nitial	Act	tion	Sign	1 &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription	Da	te	Verificatio	n	QC Inspector
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Equip/Tooling															
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Setup														-	
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Landi		1			_	General	_	7			7		,		
	-	Bending				Bend		Grain		_	Ovalize			\dashv	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa		_	Over/l	Under	tolerance	-	Temperature/Cure
	-	Cracks			L	Broken/Damaged		4 '	on Incomplete	<u> </u>	Part In			-	Weld
	-	Crushed/	Crimped		L	Burrs		4	ions Incomplete/I	Unclear	Part Lo	-	issing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	<u> </u>	Part M	1oved			
		Heat Trea	at			Countersink		Mislabe	led	<u></u>	Positio	oned V	Vrong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power	Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

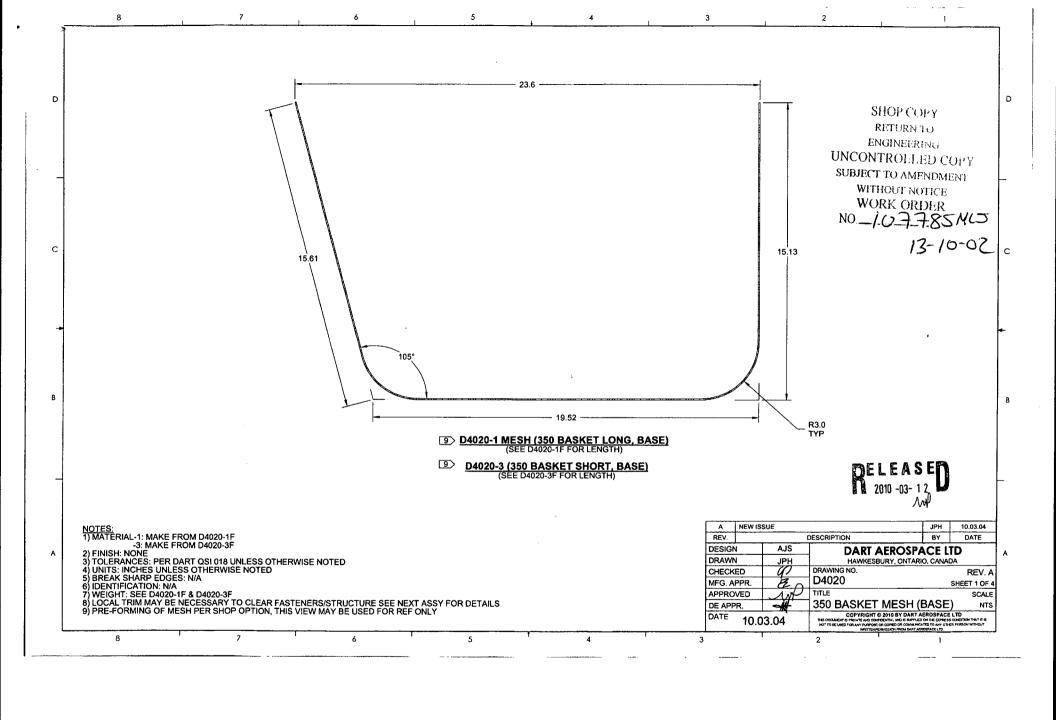
Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

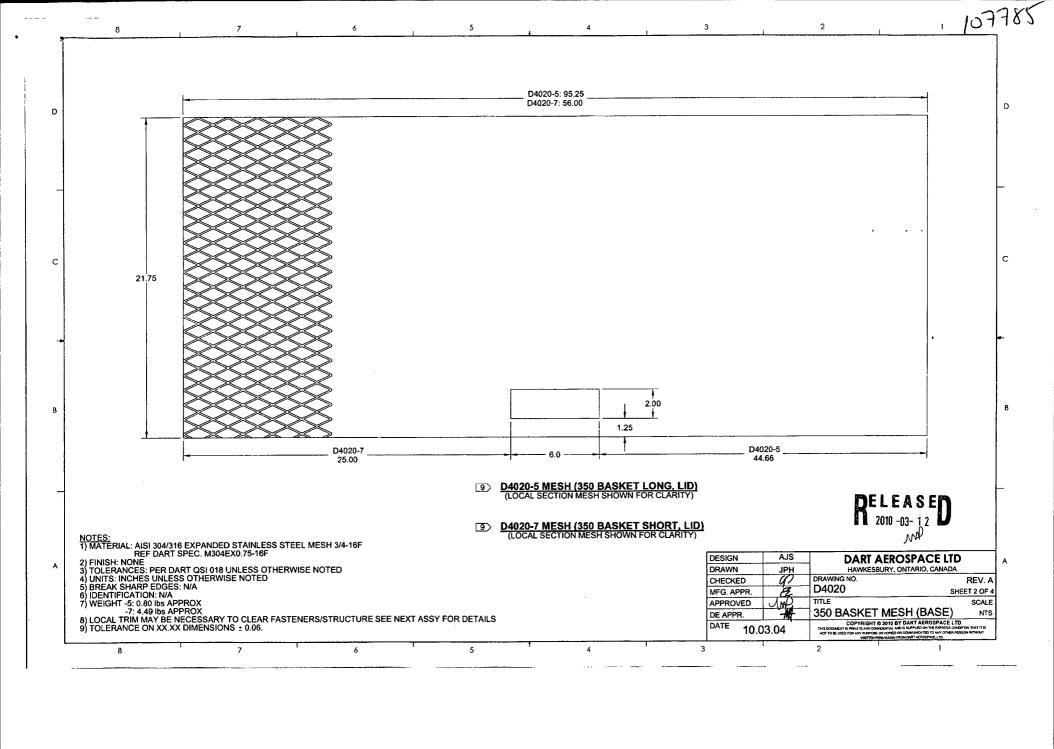
Finish Folio



		DQA:	Date:	-
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ICR: Yes / No	WORK ORDER NON-CONFORMANCE / OPDATE			

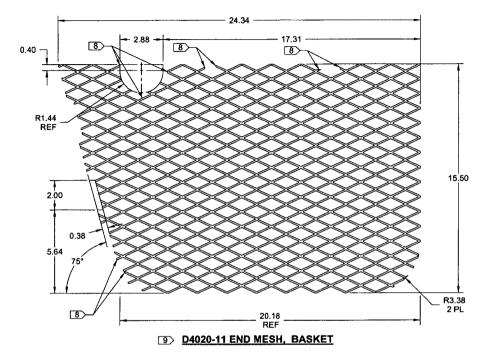
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Work Orde	a ř.					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
	_					Rework		Skid-tube	Crosstube Small Fab	Dro	Water Jet d. Eng. Coor.	Engineering Quality
Part N	vo					Scrap	_,	Machining	}	4	· —	Other
						Use-as-is	The	rmoforming	Finishing	Rec/Stol	re/Packaging	- Other
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		entre No	ot Concer	ntric to	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
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		rushed/0	Crimped			Burrs	Instru	ictions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		uffs				Contamination	Mair	tenance	L	Part Moved		
	Пн	eat Trea	t			Countersink	Misla	beled		Positioned V	Wrong	-
	Ir	rspection	n Strip in	Tube		Cut Too Short	Misre	ead		Power Loss/	'Surge	Other
	R	ipples in	Bend			Drill Holes	Offse	t				
	T	orque W	aves in E	xtrusio	n 🗌	Drawing	Out	f Calibration				
	T	urning S	equence			Finish	Out	of Sequence				
	\square	Vave/Tw	ist in Tul	ne .	T T	Folio	Outs	de Dimensions				



			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

											QA Closed:	Da	te:	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part NCR N	٠ ا٠٠					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	Ī	nitial	Act	tion	Sign &			· · · · · · · · · · · · · · · · · · ·
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verificatio	n	QC Inspector
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Operator														
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Landi		ŧ				General		1		F	, 1		$\overline{}$	
	-	Bending				Bend		Grain		ļ	Ovalized			Pressure/Forced
	-	Centre No	ot Conce	ntric to	o/s	BOM/Route	_	Hardwa			Over/Under			Temperature/Cure
1	\vdash	Cracks			<u> </u>	Broken/Damaged		i '	ion Incomplete		Part Incorred		${m o}$	Weld
	-	Crushed/	'Crimped		ļ	Burrs	<u> </u>	(tions Incomplete/	Unclear	Part Lost/Mi	ssing	Ш	Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination	<u> </u>	Mainte		_	Part Moved			
	<u> </u>	Heat Trea			<u> </u>	Countersink		Mislabe		<u> </u>	Positioned V	_	$\overline{}$	
	<u> </u>	Inspectio	-	Tube	$oxdapsymbol{oxed}$	Cut Too Short		Misrea	d		Power Loss/	Surge	Ш	Other
	\vdash	Ripples ir				Drill Holes	\vdash	Offset						
	<u> </u>	Torque V			n	Drawing	\vdash	i	Calibration					
	<u></u>	Turning S			L	Finish	_	1	Sequence					· · · · · · · · · · · · · · · · · · ·
	1	Wave/Tw	vist in Tul	oe e	l	Folio	1	Outside	Dimensions					



NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 122 ibs

7) WEIGHT: 1.22 lbs

8

7) WEIGHT 1.22 IDS 8 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS 9) TOLERANCE ON XX.XX DIMENSIONS \pm 0.06.

DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. A CHECKED D4020 MFG. APPR. SHEET 3 OF TITLE APPROVED SCALE 350 BASKET MESH (BASE) DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD
THE DOCUMENT IS PRIVATE AND CONFEDENTIAL AND IS SUPPLED ON THE DOPIESS CONSTITUTION TO DE USED FOR ANY APPOSE OR OPENED ON COMMENTED TO ANY OTHER PERSON
WINTON PEQUASION PROMOMENT ADDRESS. DATE 10.03.04

8

											DQA:	Date:	
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Work Orde	o ř·					DISPOSITION			AGAINST [DE.	PARTMENT/	PROCESS	
Part N						Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		1	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
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	Ce	ntre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cra	icks				Broken/Damaged		Inspecti	ion incomplete		Part Incorred	:t	Weld
	Cru	ished/0	rimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cu	ffs				Contamination		Mainte	enance		Part Moved		
	\square_{He}	at Trea	t			Countersink		Mislabe	eled		Positioned W	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

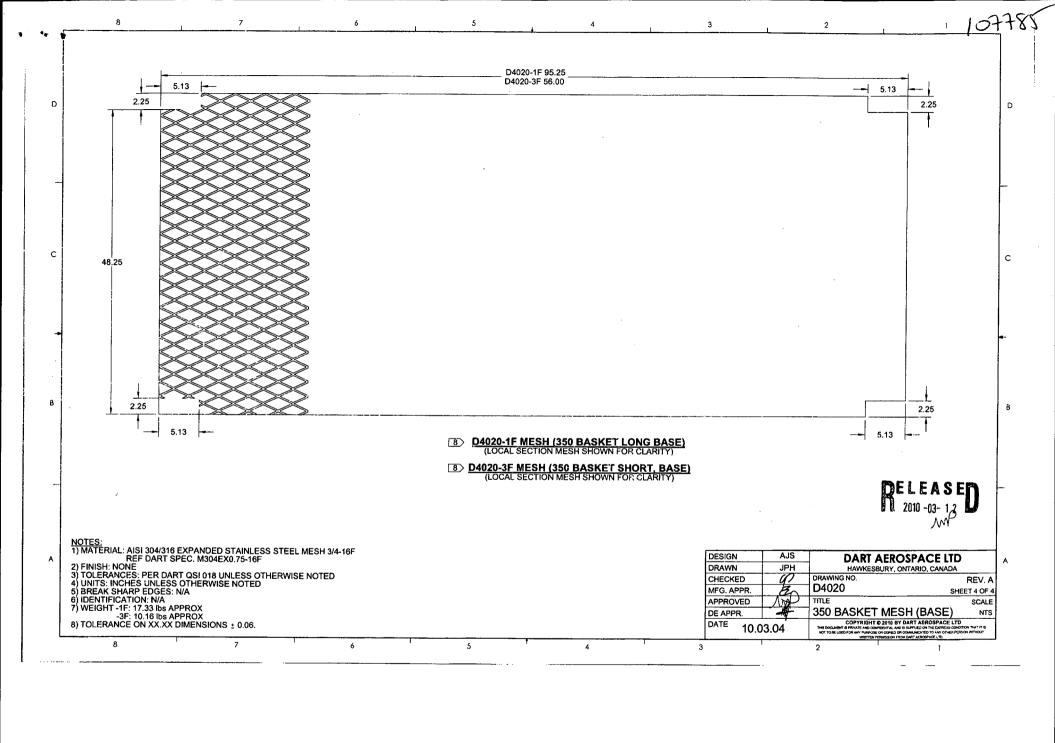
Torque Waves in Extrusion

Cut Too Short Drill Holes

Drawing

Finish

Folio



NCR:	Yes	/	No	
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NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:																	
Vork Order:							DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet Enging Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other		
Root					Desc	rin	tion of work order update		nitial	Act	ion		Sign &			_	
Cause		Date	Step	Qty		•	r Non-conformance		ief Eng		iption		Date	Verificatio	n	QC Inspector	
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining			•							•							
FAULT CATEGORY																	
Landir		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of 9	ion Incomplete ions Incomplete/L enance eled d Calibration Sequence	Jnclear		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
		Wave/Twist in Tube					Folio	1	Outside	Dimensions						·	

DQA:

Date: